Nork Order ID
 121597

 Thursday, June 26, 2014
 3:04:10 PM

Item ID: D3610 Revision ID: Bracke				Accept	*N900	040	100)* s	etup Star Stoj		S1* S2*	
Start Date: 6/26/1 Required Date: 6/26/1 Reference:		t Qty: 10.00 d Qty: 10.00		Λ* Λ*	Cust Item Customer:						. 1/	
Approvals: Proce	ess Plan: \(\sum_	N .75	Date: \\-0	6-30 Tooling:	D	ate:	_	R	tun Star	^t *N	R1*	
QC:				SPC (Y/N):		ate:			Stop	, *N	R2*	
Sequence ID/ Work Center ID	Oper- Descr	ation iption		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Ińsp. Stamp	
Draw Nbr	Revision N	lbr										
D3610	Rev B											
100 *100* Bandsaw	BAND			0.00				10	S		DAS 20 14-07-2	28
Jeaspa Bandsaw		Memo Cut blank 7	.900 "long	0.00							-0 -0-0	
	•	•	*						•	,		
110	-			0.00					•		SF-H-7-S	7
110 HAAS 1	HAAS	CNC VERTICAL Memo	L'MACHINING #1	0.00			•	10			JL 14-7-2 DAS 20 14-07-	28
HAAS CNC vertical machin	e #1			7: AA & Dwg D3610 Rev:	2-Deburr							
120	QC2-	Inspect parts off n	nachine FAI/FAIB	0.00				, ·			DAS JL 14-	7-5
1 20 QC Quality Control		Memo		0.00				10			DAS JL 14- 20 9-89 14-07-	-28

DQA:		- Date:										TOART
QA Closed:		Date:			WORK ORDER NON-	·CC	NFO	RMANCE / U		ork Order u	odate only	AEROSPACE
					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Work Order:					, <u>.</u>				_	7	_	- —
				٠.	Rework			Skid-tube	Crosstube	_	Water Jet	Engineering
Part No.	·				Scrap			Machining	Small Fab	4	d. Eng. Coor.	Quality
					Use-as-is			noforming	Finishing	Kec/Stol	re/Packaging	Other
NCR No.	• ———				Suspected Unapproved			Large Fab	Composite		Supplier	
Root				Desc	ription of work order update	ı	nitial	Ac	tion	Sign &		
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
Design												•
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Equip/Tooling	_											
Handling/Pre	<u> </u>										 	ŀ
Material	_		_									
Operator				ļ					•			
Offset/Setup.					•							
Process •	4											
Supplier												
Training	4		1									
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Unapproved	<u> </u>			<u>L</u>		<u> </u>				<u> </u>		
ت بر بربر						FA	JLI CA	regory				
Landing	_				General		l = 11 = 70			Outside Dim	onsions [Pressure/Forced
<u> </u>	Bending	_		<u> </u>	Bend			rogram		Over/Under	├ -	Set-up
		lot Conce	ntric	-	BOM/Route	⊢	Grain Hardwa	uro.	 	Part Incorre	F	Temperature/Cure
<u> </u>	Cracks	/6'	644	-	Broken/Damage/Defect	\vdash	l	ire ion Incomplete/U	Inqualified	Part Lost/M		Weld
2.0		ink/Ripple	e/wave	\vdash	Burrs	_	1	ions Incomplete/		Part Moved	F-	Wrong Stock Pulled
	Cuffs	_		-	Contamination Countersink	\vdash	1	ned/off center	_	Positioned \		
23-e	Crushing Heat Tre			-	Cut Too Short	\vdash	Mislabe	•	-	Power Loss/		Other
 	-	at on Strip in	Tubo	-	Drawing	\vdash	Misrea		1	」		
-	Marks/C		i iube	-	Drill Holes		Off-set			·		-
-	⊣	sequence	1	·	Finish		4	Calibration				
		wist in Tul		F	Fit/Function		4	Sequence				
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Page 2

= -	20, 2017 5.0	7.101111								
Item ID: Revision ID: Item Name:	D3610-041 Bracket			Accept	*N900	04010	n * ^s	Setup Sta		S1* S2*
Start Date: Required Date: Reference:	6/26/14	Start Qty: 10.00 Req'd Qty: 10.00	*10* *10*		Cust Item I Customer:	D:			"IN	. 7/"
Approvals:	Process Pla	ın: <u> </u>	Date:	Tooling: SPC (Y/N):		ate:	. -	Run Sta	P	R1* R2*
Sequence ID/ Work Center II	D	Operation Description QC8- Inspect parts - seco	nd check	Set Up/ Run Hours 0.00	Tool ID	Tool # Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control		Memo	3	0.00	on 141	07/29	_/0	_18		-
*140 *140* Small Fab Small Fab		Small Fab Memo 1-C'SINK A	S PER DWG D3610	0.00			10×			14/07/30
150 *150* QC Quality Control		QC5- Inspect part compl	eteness to step on W/O	0.00 DAS 38 9-89 0.00 /4/07	9	AS 16 -89 -(\1\7\3\	(0))		

DQA:			Date:				~	NEO	DAAAAICE / LIDDATE				DART
QA Closed:			Date:			WORK ORDER NON-	-CC	JNFO	RIVIANCE / UPDATE	W	ork Order up	odate only	AEROSPACE
						DISPOSITION			AGAINS	T DE	PARTMENT	/PROCESS	
Work Orde	er: .										1	Mater let	
Part N	lo.					Rework Scrap			Skid-tube Crosstube Machining Small Fal		Pro	Water Jet d. Eng. Coor.	Engineering Quality
, 4	•					Use-as-is			noforming Finishin	g	4	re/Packaging	Other
NCR N	١ο٠.					Suspected Unapproved			Large Fab Composite	e]	Supplier	
	_		1 1		Doss	rintian of work order undate		nitial	Action		Sign &		
Root	ı	Data	Ston	Qty	Desc	ription of work order update or non-conformance	l	iiitiai ief Eng	1		Date	Verification	✓ QC Inspector
Cause	-	Date	Step	Qty		of flori-comormance	CII	iei Liig	Description		Dute	Vermedelon	, 00
Design Doc/Data	\dashv					,							
Equip/Tooling	\dashv												·
Handling/Pre													
Material						A.r.							
Operator											:		
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Training													
Transport							1						
Unapproved								<u></u>					<u> </u>
					*		FAI	ULT CA	TEGORY				
Landi	ng (Gear	•			General		,		_	7	<u> </u>	1
		Bending	•			Bend		1	Program	<u> </u>	Outside Dim		Pressure/Forced
		Centre N	ot Concer	ntric	<u> </u>	BOM/Route	├	Grain		-	Over/Under		Set-up
	L.	Cracks				Broken/Damage/Defect	<u> </u>	Hardw		-	Part Incorre	<u> </u>	Temperature/Cure
		Crimp/Kii	nk/Ripple	:/Wave	<u> </u>	Burrs	<u> </u>	- '	ion Incomplete/Unqualified	\vdash	Part Lost/M	issing	Weld
		Cuffs			<u> </u>	Contamination	<u></u>	4	tions Incomplete/Unclear	·	Part Moved		Wrong Stock Pulled
		Crushing			<u> </u>	Countersink	<u> </u>	4	gned/off center	\vdash	Positioned V	_	Joshan
	\vdash	Heat Trea			<u> </u>	Cut Too Short	<u> </u>	Mislab		L	Power Loss/	ourge	Other
	<u> </u>	Inspectio	-	Tube	<u> </u>	Drawing	<u> </u>	Misrea					
	<u> </u>	Marks/Cl			\vdash	Drill Holes	<u></u>	Off-set					
	<u> </u>	Turning S			<u> </u>	Finish	\vdash	4	Calibration				
		Wave/Tw	vist in Tub	oe e		Fit/Function		Out of	Sequence				

Wo	rk O	rder	ID	121597	7
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121597

Page 3

Thursday, June	26, 2014 3:0	4:10 PM										-
Item ID: Revision ID: Item Name:	D3610-041 Bracket			Accept	*N900)040	100)*	Setup	Start Stop	171	S1* S2*
Start Date: Required Date: Reference:	6/26/14	Start Qty: 10.00 Req'd Qty: 10.00	*10 [*]		Cust Item Customer:							
Approvals:	Process Pla	in:	Date:	Tooling:	D	Date:	-		Run	Start	*N	R1*
	QC:		Date:	SPC (Y/N):	D	Pate:				Stop	*N	R2*
Sequence ID/ Work Center II 160 *160* Powdercoat	D	Operation Description Grey Sandtex(Ref:4.3.5.6) per QS1005 4.3	Set Up/ Run Hours 0.00	Tool ID	Tool #	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp DAS 41 9-89
Powder Coating		Memo START TIMI <u>3コム</u>	E: <u>445</u> FINISH TIME:	0.00 OVEN TEMPERATURE:								14-8-10
170		QC3- Inspect Part Finish		0.00								-
170 QC Quality Control		Мето		0.00				16_	*			1408/11
180				0.00								_
1 2 0 Small Fab		Small Fab Memo		0.00				10			£8	14-00-
Small Fab		Rivet Nut Pla	ate as per Dwg D3610									

DQA:		Date	e:		_			_				"DART
QA Closed:		Date	2:		WORK ORDER NON-	-C(ONFO	RMANCE / UPD		ork Order up	odate only	AEROSPACE
					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	•
Work Orde	r:					.			7.07.III.01 DE			· —
					Rework			├	Crosstube		Water Jet	Engineering
Part N	o				Scrap			Machining	Small Fab	-4	d. Eng. Coor.	Quality
					Use-as-is		Thern	noforming	Finishing	Rec/Stor	e/Packaging	Other
NCR N	o				Suspected Unapproved			Large Fab C	omposite]	Supplier	
Root				Desc	ription of work order update		nitial	Action		Sign &		
Cause	م ا	ate Step	Qty		or non-conformance	ı	ief Eng	ł		Date	Verification	QC Inspector
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Doc/Data												
Equip/Tooling	\dashv					l						
Handling/Pre												
Material **	\neg		1									
Operator									•			
Offset/Setup												,
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Unapproved												
						FA	ULT CA	TEGORY				
Landin	ng Gear				General		•		_	7		٦
	Ber	ding		L	Bend	L	Folio/F	Program	_	Outside Dim	 	Pressure/Forced
i . [Cer	tre Not Cond	entric		BOM/Route		Grain		_	Over/Under	<u> </u>	Set-up
	Cra	cks			Broken/Damage/Defect		Hardwa			Part Incorre	—	Temperature/Cure
[Crir	np/Kink/Ripp	ole/Wave	· · L	Burrs		- '	ion Incomplete/Unqua		Part Lost/Mi	ssing	Weld
	Cuf	fs		<u> </u>	Contamination	<u>_</u>	-	tions Incomplete/Uncl	lear	Part Moved		Wrong Stock Pulled
		shing		L	Countersink	_	-1	gned/off center	<u> </u>	Positioned V	_	ا مر
		t Treat			Cut Too Short	<u> </u>	Mislab		. [Power Loss/	Surge	Other
	_	ection Strip	in Tube		Drawing		Misrea					<u> </u>
	_	rks/Chatter			Drill Holes	\vdash	Off-set					
		ning Sequen			Finish		-	Calibration				
1	Wa	ve/Twist in T	ube		Fit/Function	\perp	Out of	Sequence				

121597

Page 4

Thursday, June 26, 2014 3:04:10 PM Item ID: D3610-041 Accept *N900040100* Setup Start Revision ID: Stop Item Name: Bracket *10* **Start Date:** 6/26/14 **Start Oty:** 10.00 **Cust Item ID:** Required Date: 6/26/14 Rea'd Otv: 10.00 *10* Customer: Reference: Start Run Process Plan: Date: Approvals: Tooling: Date: Stop OC: Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Reject Accept Reject Insp. **Work Center ID Description** Run Hours Code Oty Oty Number Stamp 190 QC5- Inspect part completeness to step on W/O 0.00 DAS DAS *100* 16 OC 0.00 Memo Quality Control Identify as per dwg & Stock Location: 5705/ 200 0.00 *200* DAS 10X AUG 1 3 2014 28 Packaging 0.00 Memo 9-89 Packaging 210 QC21- Final Inspection - Work Order Release 0.00 MLJ 14-08-15 MLJ 14-08-15 OC 0.00 Memo **Ouality Control**

DQA:			_ Date:			-							TOART
QA Closed:			Date:			WORK ORDER NON	-C(ONFO	RMANCE / UPD		ork Order up	odate only	AEROSPACE
QA Ciosea.			Date.				_				······································	· ·	
Work Ord	er:					DISPOSITION				AGAINST DI	EPARTMENT,	/PROCESS	
i i i i i i i i i i i i i i i i i i i	-					Rework	1		Skid-tube	Crosstube	7	Water Jet	Engineering
Part i	۷o.					Scrap			 	Small Fab	Pro	d. Eng. Coor.	Quality
	•					Use-as-is		Therr	noforming	Finishing	Rec/Stor	e/Packaging	Other
NCR I	۷o.					Suspected Unapproved			Large Fab C	Composite 🗌		Supplier	
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Root					Desc	ription of work order update	ı	Initial	Action		Sign &		
Cause	\Box	Date	Step	Qty		or non-conformance	Ch	nief Eng	Descript	ion	Date	Verification	QC Inspector
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Landi	ng (Gear				General							
	$\overline{}$	Bending				Bend		Folio/F	Program		Outside Dim	ensions	Pressure/Forced
	H	Centre N	ot Concer	ntric		BOM/Route		Grain	· ·		Over/Under	tolerance	Set-up
		Cracks			-	Broken/Damage/Defect		Hardwa	are		Part Incorre	ci 🗌	Temperature/Cure
	厂	Crimp/Ki	nk/Ripple	/Wave		Burrs		Inspect	ion Incomplete/Unqu	ıalified	Part Lost/Mi	issing	Weld
	ļ	Cuffs	,			Contamination		Instruc	tions Incomplete/Unc	clear	Part Moved		Wrong Stock Pulled
		Crushing				Countersink		Misali	gned/off center		Positioned V	Vrong	- -
		Heat Trea				Cut Too Short		Mislab	eled		Power Loss/	Surge	Other
	Ī.	Inspectio	n Strip in	Tube		Drawing		Misrea	d				
		Marks/Cl	natter			Drill Holes		Off-set					
		Turning S	Sequence			Finish		Out of	Calibration				
		Wave/Tw	vist in Tuk	эe		Fit/Function		Out of	Sequence				

MS210751 3

Location ST303

116398

Loc Qty

8

Loc Code

**

10

FF 14-08-12

DQA:			Date:												
						WORK ORDER NON-	ON-CONFORMANCE / UPDATE								
QA Closed:			Date:					Work Order update only							
NA/ and a Cond						DISPOSITION		AGAINST DEPARTMENT/PROCESS							
Work Orde	er: -					Rework	1 I	Skid-tube Crosstube Water Jet						Engineering	
Part N	lo.					Scrap			Machining	Small Fab		Proc	d. Eng. Coor.	Quality	
raiti	•0				 -	Use-as-is			noforming	Finishing	_		e/Packaging	Other	
NCR N	lo.					Suspected Unapproved			Large Fab	Composite	_	·	Supplier	1	
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Root					Desc	ription of work order update		nitial	Act	ion		Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Desci	ription	\dashv	Date	Verification	QC Inspector	
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Landi	$\overline{}$	Bending				Bend	Γ]Folio/F	Program			Outside Dim	ensions [Pressure/Forced	
,	$\vdash \vdash$	Centre No	nt Concer	ntric	-	BOM/Route		Grain	1 og ann	•	-	Over/Under	-	Set-up	
	Н	Cracks	or concei	itiic		Broken/Damage/Defect	-	Hardwa	are		-	Part Incorre	F-	Temperature/Cure	
	Н	Crimp/Kir	nk/Rinnle	/Wave		Burrs		4	ion Incomplete/U	nqualified	-	Part Lost/Mi	-	Weld	
, '	\vdash	Cuffs	ind imphic	, wave		Contamination	\vdash	4 '	tions Incomplete/		-	Part Moved	Γ.	Wrong Stock Pulled	
	\vdash	Crushing				Countersink		-{	gned/off center		П	Positioned V	Vrong	<u></u>	
		Heat Trea				Cut Too Short		Mislab				Power Loss/	Surge	Other	
		Inspectio		Tube		Drawing		Misrea	d						
		Marks/Cl	-			Drill Holes		Off-set			_				
		Turning S				Finish		Out of	Calibration						
		Wave/Tw	vist in Tub	oe .		Fit/Function		Out of	Sequence					·	

DART AEROSPACE LTD	Work Order:	121597
Description: Plate	Part Number:	D3610-1
Inspection Dwg: D3610 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing	Tolerance	Actual	Accept	Reject	Method of	Comments
Dimension		Dimension	Accept	Neject	Inspection	Comments
1.25	+/-0.030	1.248			SL08	Vem
0.250	+/-0.010	. 251			1	
0.63	+/-0.030	. 620	/			
7.75	+/-0.030	7.751				
4.25	+/-0.030	4.2475			Height	gange
2.677	+/-0.010	2.6755			l (
0.38	+/-0.030	. 3785			N	
Ø0.277	+0.006/-0.001	.277			Gauge	PiN
Ø0.201	+0.005/-0.001	. 201	/		11	
Ø0.098	+0.004/-0.001	. 098			١	
0.88	+/-0.030	. 877	/		Height	auge
0.94 x 0.50	+/-0.030	.936 V. 500			1	
0.250	+/-0.010	.250	/			
0.125 depth	+/-0.010	.124			V	

	DAS				
Measured by:	20 9-89	Audited by:	In I	Preliminary Approval:	
Date:	14-07-28	Date:	14/02/29	Date:	

Rev	Date	Change	Revised by	Approved
Α	08.04.21	New Issue P/O D3610-041	KJ/DD LA	2//
В	12.05.15	Dimensions updated per Dwg Rev B	KJ 👯	1.11
				7 1



